

Date: Friday, 7/21/2006 7:37:34 AM  
User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : DOOR SLUG  
Job Number : 28021  
Estimate Number : 10162  
P.O. Number : N/A Part Number : D2587  
This Issue : 7/21/2006 S.O. No. : N/A Drawing Number : D2587 REV A1  
Prsht Rev. : NC Project Number : N/A  
First Issue : N/A Type : MACHINED PARTS Drawing Revision : A1  
Previous Run : N/A Material : N/A  
Written By : *See Comment Below* Due Date : 8/12/2006 Qty: 32 Um: 30 Each  
Checked & Approved By : *06.07.21*  
Comment : Est D 04.05.31 Step 2 changed KJ/JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6R1500 6061-T6 Round Bar 1.5"



*0.016 sf*



Comment: Qty.: ~~0.016~~ f(s)/Unit Total: 0.4347 f(s)

6061-T6 Round Bar ~~1.5"~~ *sheet 0.040" thick*

Material: 6061-T6 Aluminum Bar Ø1.500" (QQ-A-200/8 or QQ-A-225/8)

(M6061T6R1.500)

Batch: ~~M100742~~ *M100742*

*SAD 06:08:01*

*32*

2.0 HARDINGE *water jet* HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

1-Turn Blank as per Dwg D2587

2-Deburr

*SAD 06:08:02 32*

*M.F. 06/08/02*

*32*

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*SAD 06:08:03*

*32*

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

*06-08-14 32*

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

*SC 06/08/14*

*32*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: LD Date: 06/08/17

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Friday, 7/21/2006 7:37:34 AM  
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## Process Sheet

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Drawing Name: DOOR SLUG

Job Number: 28021

Part Number: D2587

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

AS 06/08/16 (32)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST51

AS 06/08/16 (32)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

AS 06/08/17 (32)

Job Completion



U 06-08-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

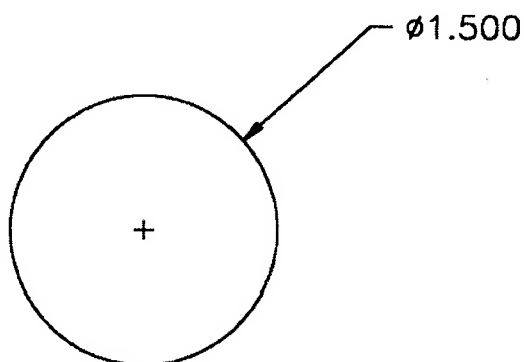
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_





DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
MIKE M	B WILLIAMS	DRAWING NO.	REV. A
CHECKED M. M.	APPROVED M. M.	D2587	SHEET 1 OF 1
DATE	TITLE		SCALE
96:07:11	DOOR SLUG		1:1
AI <del>K</del> 03.09.16		ADD 6061-T6 OPTION	

RELEASED  
96 07 23 BU



OR 6061-T6 (QA-A-200/B OR QA-A-205/B) AT  
MATERIAL: 5052-H32, 0.040 THICK  
FINISH: ACID ECTCH, ALODINE

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 28021